



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D5304-1

Job Sheet 199935



Part No: D5304-1

Job Qty: 16 pcs

Part Name: Crossbolt Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/5/19

Job Tracking No:

Due Date: 9/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D5304 REV.A IPP REV:A NEW ISSUE 15-09-24 JLM VERIFIED BY:DD

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation                     | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off        |
|-------|-------------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-----------------|
|       |                               |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                 |
| 100   | Hardinge - 1                  | 16 pcs | 9/18/19    | 9/18/19  | 0.00      | 1.17    | Hardinge - 1          |           | MRP 18/09/23    |
| 120   | QC 8                          | 16 pcs | 9/18/19    | 9/18/19  | 0.00      | 0.00    | QC 8 - 12             |           | MRP 19/09/28    |
|       |                               |        |            |          |           |         | QC 8 - 14             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 17             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 20             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 25             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 3              |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 32             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 33             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 35             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 39             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 4              |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 44             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 45             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 49             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 58             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 8              |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 9              |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 68             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 67             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 1 (A)          |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 47             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 40             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 52             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 23             |           |                 |
|       |                               |        |            |          |           |         | QC 8 - 57             |           |                 |
| 130   | Outsource - 1 - Heat Treat    | 16 pcs | 9/18/19    | 9/18/19  |           |         | MEI001-VC             | 12        | MRP 20/09-10-01 |
| 140   | Packaging 2-1 - Receive - B4B | 16 pcs | 9/18/19    | 9/18/19  | 0.00      | 0.00    | Packaging 2 - 1 - B4B |           |                 |
|       |                               |        |            |          |           |         | Packaging 2 - 2 - B4B |           |                 |
|       |                               |        |            |          |           |         | Packaging 2 - 3 - B4B |           |                 |



Container No: S216395



Part: D5304-1

Job No: 199935

Serial No/Batch: S216395

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.  
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www.dartaerospace.com

Date: 09/23/19

|                                   |           |         |           |  |                           |                                                                                                      |
|-----------------------------------|-----------|---------|-----------|--|---------------------------|------------------------------------------------------------------------------------------------------|
|                                   |           |         |           |  | Packaging 2 - 5 - B4B     | <br>OCT 0 8 2019   |
|                                   |           |         |           |  | Packaging 2 - 4 - B4B     |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 6 - B4B     |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 7 - B4B     |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 8 - B4B     |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 9 - B4B     |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 10 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 11 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 12 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 13 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 14 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 15 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 16 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 17 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 18 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 19 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 20 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 21 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 22 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 23 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 24 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 25 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 26 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 27 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 28 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 29 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 30 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 31 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 32 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 33 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 34 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 35 - B4B    |                                                                                                      |
|                                   |           |         |           |  | Packaging 2 - 36 - B4B    |                                                                                                      |
| 150 QC 6                          | 16<br>pcs | 9/18/19 | 0.00 0.00 |  | QC 6 - 9                  | <br>OCT 0 8 2019  |
|                                   |           |         |           |  | QC 6 - 68                 |                                                                                                      |
|                                   |           |         |           |  | QC 6 - 61                 |                                                                                                      |
|                                   |           |         |           |  | QC 6 - 40                 |                                                                                                      |
|                                   |           |         |           |  | QC 6 - 81                 |                                                                                                      |
| 160 Handfinish - 1-1 Chemical-B4B | 16<br>pcs | 9/18/19 | 0.00 0.16 |  | Handfinish - 1 - 1 - B4B  | <br>BEB 19-10-10. |
|                                   |           |         |           |  | Handfinish - 1 - 2 - B4B  |                                                                                                      |
|                                   |           |         |           |  | Handfinish - 1 - 3 - B4B  |                                                                                                      |
|                                   |           |         |           |  | Handfinish - 1 - 4 - B4B  |                                                                                                      |
|                                   |           |         |           |  | Handfinish - 1 - 5 - B4B  |                                                                                                      |
|                                   |           |         |           |  | Handfinish - 1 - 6 - B4B  |                                                                                                      |
|                                   |           |         |           |  | Handfinish - 1 - 7 - B4B  |                                                                                                      |
|                                   |           |         |           |  | Handfinish - 1 - 8 - B4B  |                                                                                                      |
|                                   |           |         |           |  | Handfinish - 1 - 9 - B4B  |                                                                                                      |
|                                   |           |         |           |  | Handfinish - 1 - 10 - B4B |                                                                                                      |
|                                   |           |         |           |  | Handfinish - 1 - 11 - B4B |                                                                                                      |
|                                   |           |         |           |  | Handfinish - 1 - 12 - B4B |                                                                                                      |
|                                   |           |         |           |  | Handfinish - 1 - 13 - B4B |                                                                                                      |
|                                   |           |         |           |  | Handfinish - 1 - 14 - B4B |                                                                                                      |
|                                   |           |         |           |  | Handfinish - 1 - 15 - B4B |                                                                                                      |
|                                   |           |         |           |  | Handfinish - 1 - 16 -     |                                                                                                      |

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|                                 |        |         |      |      |                                           |       |
|---------------------------------|--------|---------|------|------|-------------------------------------------|-------|
|                                 |        |         |      |      | B4B                                       |       |
|                                 |        |         |      |      | Handfinish - 1 - 17 - B4B                 |       |
|                                 |        |         |      |      | Handfinish - 1 - 18 - B4B                 |       |
|                                 |        |         |      |      | Handfinish - 1 - 19 - B4B                 |       |
|                                 |        |         |      |      | Handfinish - 1 - 20 - B4B                 |       |
|                                 |        |         |      |      | Handfinish - 1 - 21 - B4B                 |       |
|                                 |        |         |      |      | Handfinish - 1 - 22 - B4B                 |       |
| 170 QC 7                        | 16 pcs | 9/18/19 | 0.00 | 0.00 | QC 7 - 10                                 |       |
|                                 |        |         |      |      | QC 7 - 13                                 |       |
|                                 |        |         |      |      | QC 7 - 14                                 |       |
|                                 |        |         |      |      | QC 7 - 15                                 |       |
|                                 |        |         |      |      | QC 7 - 17                                 |       |
|                                 |        |         |      |      | QC 7 - 18                                 | BE TF |
|                                 |        |         |      |      | QC 7 - 19                                 |       |
|                                 |        |         |      |      | QC 7 - 2                                  |       |
|                                 |        |         |      |      | QC 7 - 28                                 |       |
|                                 |        |         |      |      | QC 7 - 3                                  |       |
|                                 |        |         |      |      | QC 7 - 30                                 |       |
|                                 |        |         |      |      | QC 7 - 34                                 |       |
|                                 |        |         |      |      | QC 7 - 36                                 |       |
|                                 |        |         |      |      | QC 7 - 37                                 |       |
|                                 |        |         |      |      | QC 7 - 41                                 |       |
|                                 |        |         |      |      | QC 7 - 47                                 |       |
|                                 |        |         |      |      | QC 7 - 48                                 |       |
|                                 |        |         |      |      | QC 7 - 51                                 |       |
|                                 |        |         |      |      | QC 7 - 58                                 |       |
|                                 |        |         |      |      | QC 7 - 59                                 |       |
|                                 |        |         |      |      | QC 7 - 60                                 |       |
|                                 |        |         |      |      | QC 7 - 9                                  |       |
|                                 |        |         |      |      | QC 7 - 68                                 |       |
|                                 |        |         |      |      | QC 7 - 50                                 |       |
|                                 |        |         |      |      | QC 7 - 67                                 |       |
|                                 |        |         |      |      | QC 7 - 40                                 |       |
|                                 |        |         |      |      | QC 7 - 24                                 |       |
|                                 |        |         |      |      | QC 7 - 43                                 |       |
|                                 |        |         |      |      | QC 7 - 61                                 |       |
|                                 |        |         |      |      | QC 7 - 81                                 |       |
| 190 Packaging 3-1 - Stock - B4B | 16 pcs | 9/18/19 | 0.00 | 0.00 | Packaging 3 - 1 - B4B                     |       |
|                                 |        |         |      |      | Packaging 3 - 2 - B4B                     |       |
|                                 |        |         |      |      | Packaging 3 - 3 - B4B                     |       |
|                                 |        |         |      |      | Packaging 3 - 4 - B4B                     |       |
|                                 |        |         |      |      | Packaging 3 - 5 - B4B                     |       |
|                                 |        |         |      |      | Packaging 3 - 6 - B4B                     |       |
|                                 |        |         |      |      | Packaging 3 - 7 - B4B                     |       |
|                                 |        |         |      |      | Packaging 3 - 8 - B4B                     |       |
|                                 |        |         |      |      | Packaging 3 - 9 - B4B                     |       |
|                                 |        |         |      |      | Packaging 3 - 10 - B4B                    |       |
|                                 |        |         |      |      | Packaging 3 - 11 - B4B                    |       |
|                                 |        |         |      |      | Packaging 3 - 12 - B4B                    |       |
|                                 |        |         |      |      | Packaging 3 - 13 - B4B                    |       |
|                                 |        |         |      |      | Packaging 3 - 14 - B4B                    |       |
|                                 |        |         |      |      | Packaging 3 - 15 - B4B                    |       |
|                                 |        |         |      |      | Packaging 3 - 16 - B4B                    |       |
|                                 |        |         |      |      | Packaging 3 - 17 - B4B                    |       |
|                                 |        |         |      |      | Plex 9/5/19 7:37 AM Dart.lajeunesse.marie |       |

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|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 18 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 19 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 20 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 21 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 22 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 23 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 24 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 25 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 26 - B4B | TF                                                                                         |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 27 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 28 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 29 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 30 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 31 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 32 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 33 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 34 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 35 - B4B |                                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  | Packaging 3 - 36 - B4B |                                                                                            |
| 200                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | QC 21 - SA                      | 16<br>pcs                      | 9/18/19          | 0.00 0.00              | QC 21 - SA - 21                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  |                        | QC 21 - SA - 70                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  |                        | QC 21 - SA - 53                                                                            |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |                                |                  |                        | <div style="text-align: right;"> <b>21</b><br/> <b>9-89</b><br/> <b>OCT 18 2019</b> </div> |
| <p>Part Op 100 - 1- Machine as per Folio FB</p> <p>Descriptions: 120 - (QC8- Inspect parts - second check)</p> <p>130 - 1--Issue P/O ; P/O <u>44654</u> HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN)</p> <p>NOTE: DETAIL C OF C REQUIRED PART ARE MADE FROM 6061-T6 MATERIAL</p> <p>140 - (Receive &amp; Inspect for Damage &amp; Mat'l Certs)</p> <p>150 - (QC6- All purchased or subcontracted products)</p> <p>160 - (Chemical Conversion Coat per QSI005 4.1), WASH SPACER AS PER QSI005</p> <p>170 - (QC7-Inspect Chemical Conversion Coat)</p> <p>190 - (Identify as per dwg &amp; Stock Location: <u>LGool</u>), ***STOCK IN SKIDTUBE CELL***</p> <p>200 - (QC21- Final Inspection - Work Order Release)</p> |                                 |                                |                  |                        |                                                                                            |
| <b>Job BOM</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                 |                                |                  |                        |                                                                                            |
| <b>Part / Item</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | <b>Component Name</b>           | <b>Quantity</b>                | <b>Operation</b> | <b>Container</b>       |                                                                                            |
| M6061T6T0.750W.125                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 6061-T6 Round Tube .750 X .125W | 6.9280 ft (.433 ea)            | 100-Hardinge - 1 | <u>5148146</u>         |                                                                                            |
| <b>Job Allocations</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                 |                                |                  |                        |                                                                                            |
| <b>Operation</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | <b>Component Part</b>           | <b>Required</b>                | <b>Inventory</b> | <b>Allocated</b>       |                                                                                            |
| 100-Hardinge - 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | M6061T6T0.750W.125              | 7                              | 23               | 0                      |                                                                                            |
| <b>Part Specifications</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                 |                                |                  |                        |                                                                                            |
| <b>Spec No</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | <b>Description</b>              | <b>Target/Tolerance</b>        | <b>Limits</b>    | <b>Type</b>            | <b>Special Comments</b>                                                                    |
| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Crossbolt Spacer                | 5.200Inches ± 0.010            | 5.210<br>5.190   |                        |                                                                                            |
| 2                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Crossbolt Spacer                | 0.750Inches + 0.008<br>- 0.001 | 0.758<br>0.749   | Diameter               |                                                                                            |
| 3                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Crossbolt Spacer                | 0.125Inches ± 0.010            | 0.135<br>0.115   |                        |                                                                                            |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_

# WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐



|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                                                                                                                                                                                                                                                                     |  |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |  |                                                   |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |  |  |  |  |
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| Job: _____<br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  | <b>DISPOSITION</b><br>Rework <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Scrap <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |  |  |  | <b>DEPARTMENT/PROCESS</b><br>Skid-tube <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Machining <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Large Fab <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Cross tube <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Small Fab <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Finishing <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Eng. (Non-AW) <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Engineering <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Water Jet <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Supplier <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |  |  |  | Date: _____ Sequence #: _____ QTY Affected: _____ |  | MRB (QS1042)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |  |  |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |  |  |  |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |                                                                                                                                                                                                                                                                                     |  |  |  | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |  |  |                                                   |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |  |  |  |  |
| Root Cause<br>Operator <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Handling/Preservation <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Material <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Product Improvement <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Process Improvement <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Human Factors <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |  |                                                                                                                                                                                                                                                                                     |  |  |  | <b>FAULT CATEGORY</b><br>Contamination <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>BOM/Route <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Incomplete/Unclear Instructions <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Drill Holes <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Fit/Function <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  |  |  |                                                   |  | Power Loss/Surge <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Folio/Program <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Grain Direction <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Weld <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Off-set/Set-up <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |  |  |  |  |  | Positioned Wrong <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Outside Tolerance <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Drawing <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Finish <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Misread <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                                                                                                                                                                                                                                                                     |  |  |  | Pressure/Forced <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Bending <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Crushing <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Cracks <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Mislabeled <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |  |  |                                                   |  | Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |  |  |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                                                                                                                                                                                                                                                                     |  |  |  | Completed By                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |  |  |                                                   |  | Lead hand / Supervisor                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |  |  |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |  |  |  |  |
| QC / QA Coordinator                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                                                                                                                                                                                                                                                                                     |  |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |  |                                                   |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |  |  |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |  |  |  |  |



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER

## POHB044654



**Supplier:** MEI001-VC  
Metcor Inc.  
560 Boul. Arthur Sauve  
Saint-Eustache  
QC  
J7R 5A8 Canada  
Phone: 450 473 1884  
Fax: 450 491 5498

**Attention:** Bejenaru, Livia

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**PO No:** POHB044654  
**PO Date:** 10/1/19  
**Due Date:** 10/18/19  
**Purchase Order Revision:**  
**Revision Date:**  
**Ship-To Contact:** Guerin, Kimberley  
Phone: 613-632-5200 Ext: 298  
kguerin@dartaero.com

**Via:** Ground  
**Pymt Terms:** Net 30  
**Freight Terms:**  
**Special Comments:**

**E-MAILED**  
2019-10-02

### Items

| Line Item           | Job    | Part    | Description                                                                                                                                                                                                     | Status        | Account | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price  |
|---------------------|--------|---------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|---------|----------|----------------|-------------------|---------|------------------|-----------------|
| 1                   | 199935 | D5304-1 | Crossbolt Spacer<br>: Various STC's<br>1-Issue<br>P/O<br>HEAT TREAT TO T4/T42<br>CONDITION<br>MIN. UTS=30 KSI (60 HREW<br>MIN)<br>NOTE: DETAIL C OF C<br>REQUIRED<br><br>PART ARE MADE FROM<br>6061-T6 MATERIAL | Firmed<br>X31 |         | 10/18/19 | 31 pcs         | 0 pcs             | 31 pcs  | \$22.516/pcs     | \$698.00        |
| <b>Grand Total:</b> |        |         |                                                                                                                                                                                                                 |               |         |          |                |                   |         |                  | <b>\$698.00</b> |

### Order Notes

Procurement Quality Clauses  
A005 right of entry  
A012 chemical and physical test report  
A016 personnel qualification  
A017 raw material identification (as applicable)

A022 Apical Processing  
A024 process certifications  
A026 certification of material conformance

A041 quality management system  
A042 dart notification by supplier  
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

Plex 10/2/19 2:52 PM Dart.Guerin.Kimberley

# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ  
ST-EUSTACHE, QC J7R 5A8  
Tel: 450-473-1884 / Fax: 450-491-5498

## Reçu de livraison

Delivery Receipt

| BON DE TRAVAIL<br>Order | EXPÉDITEUR<br>Shipper ID | BON D'EXPÉDITION<br>Shipper |
|-------------------------|--------------------------|-----------------------------|
| 339745                  | 1                        | 140523                      |

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT / Customer 215

**DART AEROSPACE**  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
Ph: 613-632-5200  
Fax: 613-632-1053



LIVRÉ À / Shipped To

**DART AEROSPACE**  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
Ph: 613-632-5200  
Fax: 613-632-1053

| COMMANDE DU CLIENT<br>Customer PO | BON DE LIVRAISON DU CLIENT<br>Customer Shipper No. | TYPE DE MATÉRIEL<br>Material Type | DATE DE LA COMMANDE<br>Order Date | TRANSPORTEUR<br>Carrier |
|-----------------------------------|----------------------------------------------------|-----------------------------------|-----------------------------------|-------------------------|
| HB044654                          |                                                    | AL-6061                           | 2019/10/1                         | CLIENT                  |

| QUANTITÉ<br>Quantity | No. PIÈCE<br>Part No. | NOM DE LA PIÈCE<br>Part Name | DESCRIPTION DE LA PIÈCE<br>Part Description | POIDS<br>Weight |
|----------------------|-----------------------|------------------------------|---------------------------------------------|-----------------|
|----------------------|-----------------------|------------------------------|---------------------------------------------|-----------------|

31 D5304-1  
(31) D5304-1  
JOB 199935

4,

1 BOITE DE CARTON

| TYPE DE CONTENEUR<br>Container Type | # DE CONTENEURS<br># Of Containers | COMMENTAIRES CONTENEUR<br>Container Comments |
|-------------------------------------|------------------------------------|----------------------------------------------|
| BOITE DE CARTON                     | 1                                  |                                              |

### CERTIFICAT

|                             |  |
|-----------------------------|--|
| EXPÉDIÉ PAR:<br>Shipped by: |  |
|-----------------------------|--|

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 31

POIDS EXPÉDIÉ / Weight Shipped : 4,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

**RECEIVED**

OCT 08 2019

**DART AEROSPACE LTD.**

APPROUVÉ  
*[Signature]*

### CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 31

POIDS EXPÉDIÉ / Weight Shipped : 4,00

**Signature:**

**Date:**

EXPÉDIÉ LE / Shipped On : 2019/10/07

# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

## Certificat de Conformité Détaillé

Detailed Certificate of Compliance

| BON DE TRAVAIL<br>order | CHARGEMENT<br>load |
|-------------------------|--------------------|
| 339745                  | 1                  |

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

1

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

| COMMANDE DU CLIENT<br>customer po | CLASSIFICATION PIECE<br>part classification | MATÉRIEL<br>material | MAÎTRE D'OEUVRE<br>prime contractor | PROGRAM |
|-----------------------------------|---------------------------------------------|----------------------|-------------------------------------|---------|
| HB044654                          | N/A                                         | AL-6061              |                                     |         |

### SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

| EXIGENCE / requirement | SPÉCIFICATIONS / specified | TESTS EXÉCUTÉS / performed                | RÉSULTATS DE TESTS / results |
|------------------------|----------------------------|-------------------------------------------|------------------------------|
| CONDUCT                | 35 - 43 %IACS              | 31                                        | 40.4 - 41.2 %IACS            |
|                        |                            | 60 KHZ                                    |                              |
| HARDNESS               | 60 HREW MIN                | 10                                        | 67 - 69.5 HREW               |
|                        |                            | (916) MESURE EN HR15TW = 66,3-67,5 HR15TW |                              |

| QUANTITÉ<br>quantity | POIDS<br>weight | DESCRIPTION DES PIÈCES<br>parts description |
|----------------------|-----------------|---------------------------------------------|
| 31                   | 4               | D5304-1<br>(31) D5304-1<br>JOB 199935       |
|                      |                 | 1 BOITE DE CARTON                           |

### COMMENTAIRES / comments

SOLUTION ANNEAL 985°F - 35 MINS

AGE HARDEN AMBIANT

Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification.

All HT operations were performed in compliance with the required HT specification and all verifications have been performed



# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

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Télécopieur / Fax production: 450 491-6454

## Certificat de Conformité Détaillé

Detailed Certificate of Compliance

| BON DE TRAVAIL<br>order | CHARGEMENT<br>load |
|-------------------------|--------------------|
| 339745                  | 1                  |

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

This document and any attached documents may contain confidential or proprietary information and may be subject to export control laws and regulations. If you are not the intended recipient, you are notified that any dissemination, copying of this e-mail and any attachments thereto or use of their contents by any means whatsoever is strictly prohibited. Unauthorized export or re-export is prohibited.

APPROUVÉ par / Approved by:

DATE: 2019-10-07

Lucie Desmarais  
QA Technician



# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

## Certificat de Conformité

Certificate of Compliance

| BON DE TRAVAIL<br>order | CHARGEMENT<br>load |
|-------------------------|--------------------|
| 339745                  | 1                  |

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

| COMMANDE DU CLIENT<br>customer po | CLASSIFICATION PIECE<br>part classification | MATÉRIEL<br>material | MAÎTRE D'OEUVRE<br>prime contractor | PROGRAM |
|-----------------------------------|---------------------------------------------|----------------------|-------------------------------------|---------|
| HB044654                          | N/A                                         | AL-6061              |                                     |         |

### SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

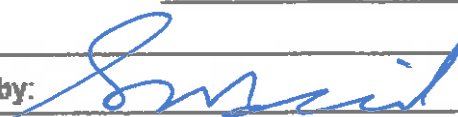
| EXIGENCE / requirement | SPÉCIFICATIONS / specified | TESTS EXÉCUTÉS / performed | RÉSULTATS DE TESTS / results                                   |
|------------------------|----------------------------|----------------------------|----------------------------------------------------------------|
| CONDUCTIVITY           | 35 - 43 %IACS              | 31                         | 40,4 - 41,2 %IACS                                              |
| HARDNESS               | 60 HREW MIN                | 10                         | 67 - 68,5 HREW<br>(916) MESURE EN HR15TW = 68,3-67,5<br>HR15TW |

| QUANTITÉ<br>quantity | POIDS<br>weight | DESCRIPTION DES PIÈCES<br>parts description                    |
|----------------------|-----------------|----------------------------------------------------------------|
| 31                   | 4               | D5304-1<br>(31) D5304-1<br>JOB 199935<br><br>1 BOITE DE CARTON |

15/10/19

### COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2019-10-06

APPROUVÉ